

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018119**Date Inspected:** 08-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 007278

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK006A1-002-014, 015, 028, 029
2. BK004A1-001-008, 038, 004, 013
3. BK006A1-002-016, 017, 018, 019, 020, 021
4. BK004A1-010-008, 038, 004, 013

Ultrasonic Testing (UT) – NWIT Document No: 007274

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Suspender Bracket. The weld designations reviewed are as follows:

1. SB022-106-003

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2. SB023-106-003

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SB018-100-005 located on Suspender Bracket SB100W. ZPMC Welder is identified as 062807. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SB018-096-001 located on Suspender Bracket SB90W. ZPMC Welder is identified as 062783. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2233-Tc-U4b-F.

FCAW welding of weld joint SB018-100-019 and 020 located on Suspender Bracket SB100W. ZPMC Welder is identified as 062807. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on sole and Clip plate of OBG Bike Path BK004A-001 and BK004A-010.

FCAW welding of weld joint BK004A1-001-030, 031, 032, 033, 034, 035, 036, 037, 039, 040, 041 and 042 located on clip plate of OBG Bike Path. ZPMC Welder is identified as 062783 and 062807. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint BK004A1-010-030, 031, 032, 033, 034, 035, 036, 037, 039, 040, 041 and 042 located on clip plate of OBG Bike Path. ZPMC Welder is identified as 062783 and 062807. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

Description of Incident: During random Quality Assurance visual and work in progress of welds located on OBG Bike Path and Suspender Bracket at Bay 19, QA Inspector observed that bike path anchor house pipe throats were damaged while handling material/welding pipe over the deck plate and the damaged anchor pipe fit-up over deck plate. The bike path is identified BK004A-004. The pipe joining weld number is identified as BK004A5-004-084. In suspender bracket, during weld bevel gouging ZPMC personnel damaged base metal. The affected suspender bracket is identified as SB096W. Regarding these issues, this QA inform to ZPMC QC Mr. Xu Tao that take corrective action as per contract documents. See the attached pictures.

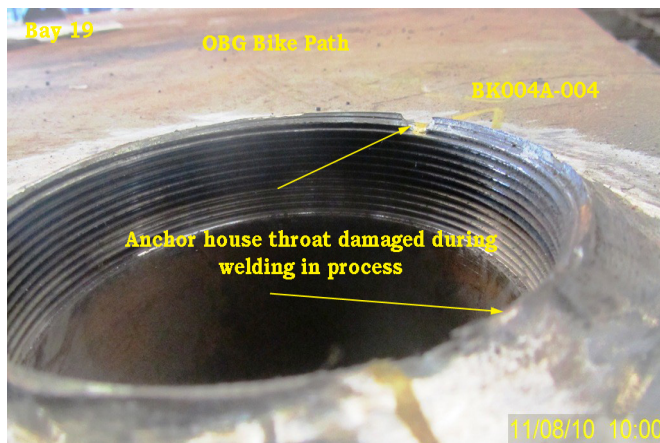
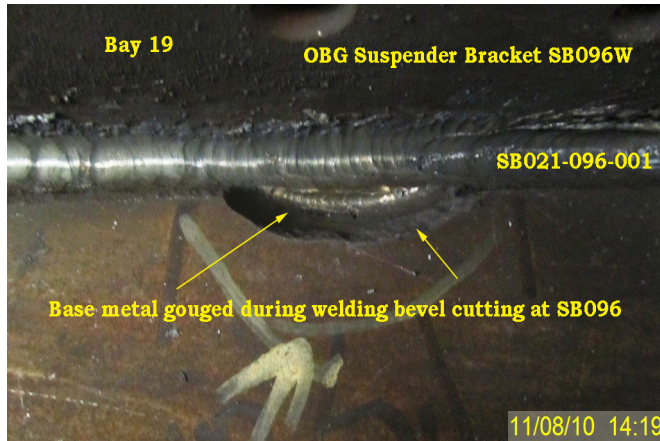
Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer

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